

Work Order ID 71475

Monday, July 04, 2011 3:24:14 PM



ASAP

Page 1

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 7/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: mf

Date: 1-07-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3296	Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

8/11/07/18 (2)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/11/07/18

(4)

120

0.00



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M 115128

Powdercoat

Memo

0.00

Powder Coating

START TIME:

3:00

OVEN TEMPERATURE:

FINISH TIME:

3:30

N. B. 11-7-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 7/4/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

4 4 11/07/20

140



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

11/07/20 (4)

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

11/07/20

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 7/4/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 218

0.00



Packaging

Memo

0.00

Packaging

11/7/21 50

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/22 2011-07-21 41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71475

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 7/4/2011

Required Date: 7/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD6 Washer	NAS1149DN632J	Purchased	No			140	Each	50.0000	1	6			
<div> <div> </div> <div> 4 M116978 (4x) </div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST347	50						
						104537	50						
D2137 Decal - No Step		Manufactured	No			140	Each	4.0000	1	6			
<div> <div> </div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	4						
						68923	4						
D2419 Handle		Manufactured	No			140	Each	14.0000	1	6			
<div> <div> </div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	14						
						69732	14						
D2462 Seal		Manufactured	No			140	f	459.2004	0.3333	1.9998			
<div> <div> </div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST404	459.2004						
						48530	459.2004						
D2728-1 Dart Logo label		Manufactured	No			140	Each	0.0000	0	0			
<div> <div> </div> </div>													

EP 11/07/20

EP 11/07/20

EP 11/07/20

EP 11/07/20

EP 11/07/20

1.3332

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 71475

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 7/4/2011

Required Date: 7/11/2011

Start Qty: 6.00

Required Qty: 6.00

D3161-7 Manufactured No



Hinge 14.0"

D3161-9 Manufactured No



Hinge 17.0"

100 Each 0.0000
B71647 (44)



6

7/5/11/07/20

100 Each 2.0000



6

7/5/11/07/20

Location Loc Qty Loc Code

ST037

2

68894

2

D3296-1 Manufactured No



Door Panel

100 Each 4.0000



6

7/5/11/07/20

Location Loc Qty Loc Code

ST186

4

70068

4

D3296-3 Manufactured No



Door Panel

100 Each 6.0000



6

7/5/11/07/20

Location Loc Qty Loc Code

ST186

6

68482

6

MS20470AD4-4 Purchased No



Rivet, Universal Head

140 Each 1,196.000



25

150

7/5/11/07/20

Location Loc Qty Loc Code

ST139

618

117423

618

ST319

578

116188

512

116391

66

100

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 3

Monday, July 04, 2011 3:24:11 PM

Work Order ID: 71475



Parent Item: D3296-041



Parent Item Name: Door Assembly

Start Date: 7/4/2011

Required Date: 7/11/2011

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-6

Purchased

No

100

Each

3,481.000

1

6



Rivet, Universal Head

9/5/11/07/20

Location

Loc Qty

Loc Code

ST319

3481

117395

1966

117887

1515

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

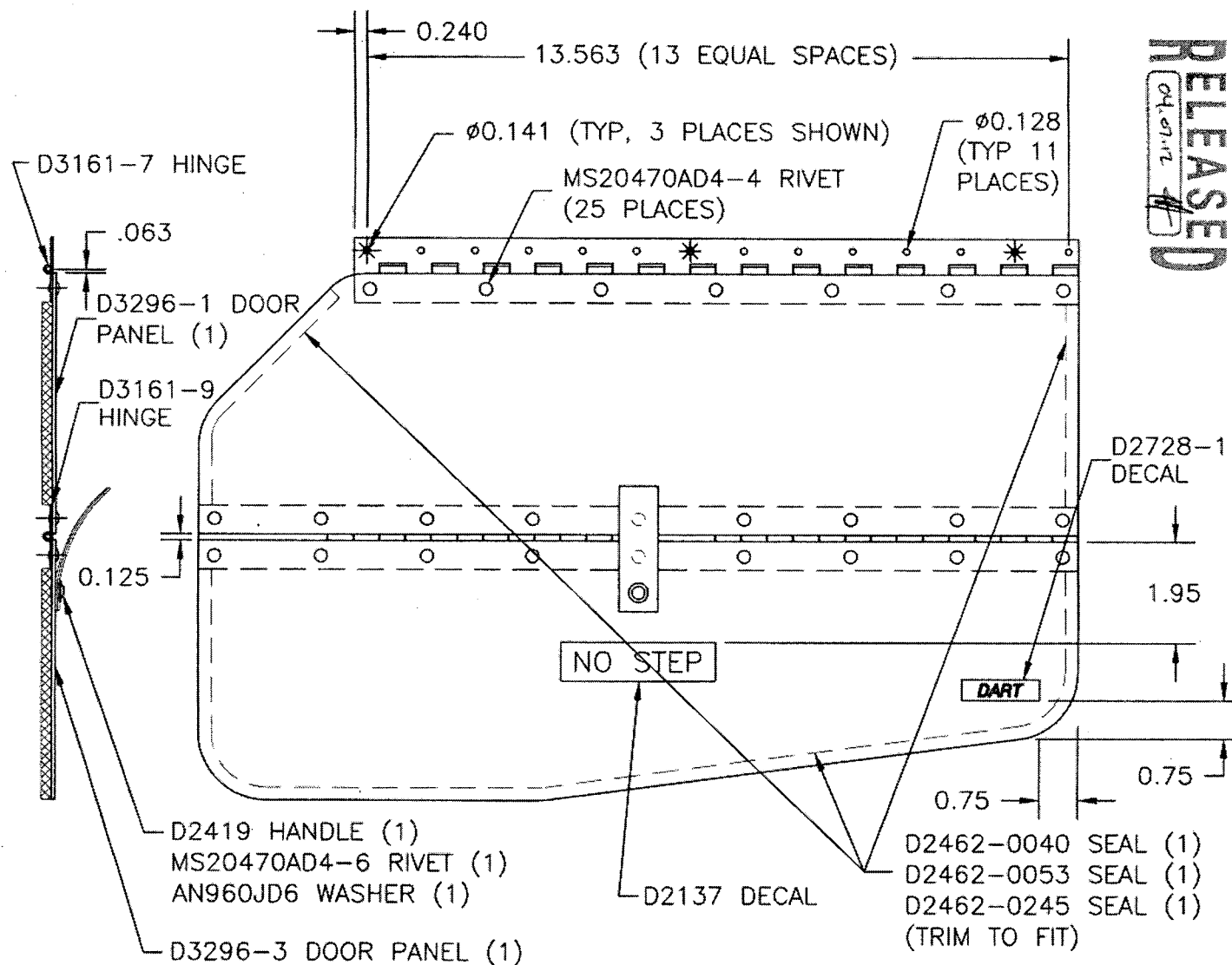
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
04.07.12

DESIGN	DRAWN BY	DART AEROSPACE LTD
UP	UP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D3296
DATE	TITLE	REV. A
04.06.28	DOOR ASSEMBLY	1 OF 2
A	04.06.28	SCALE
	NEW ISSUE	1:3



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

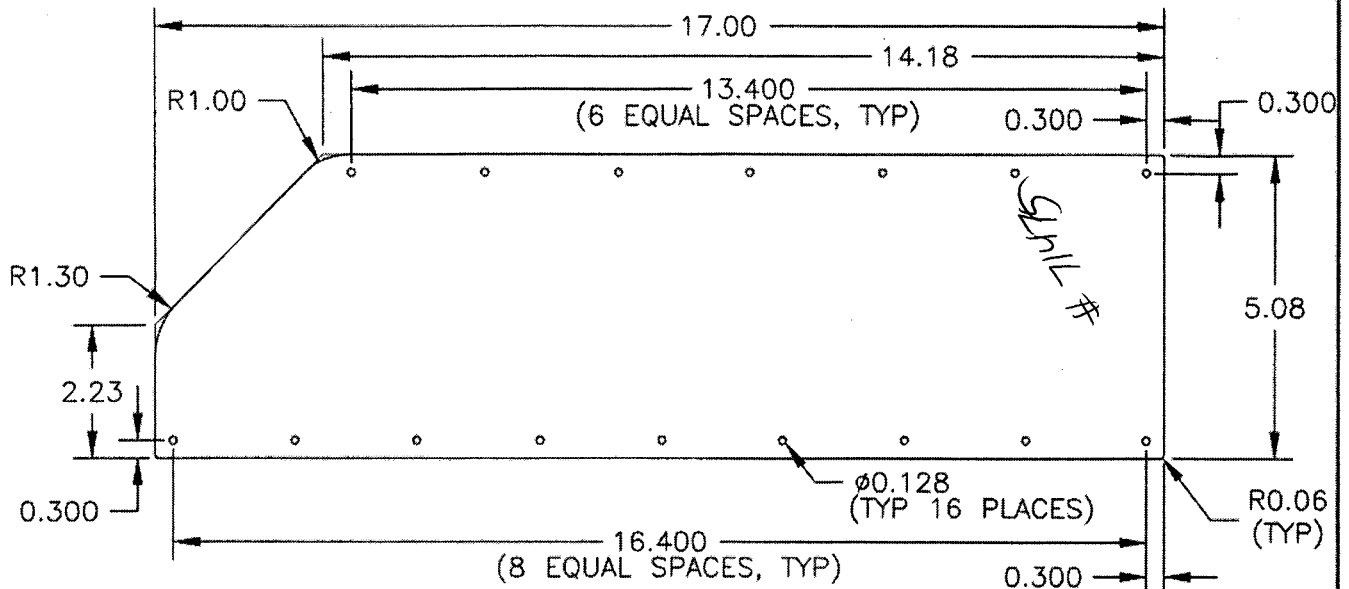
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

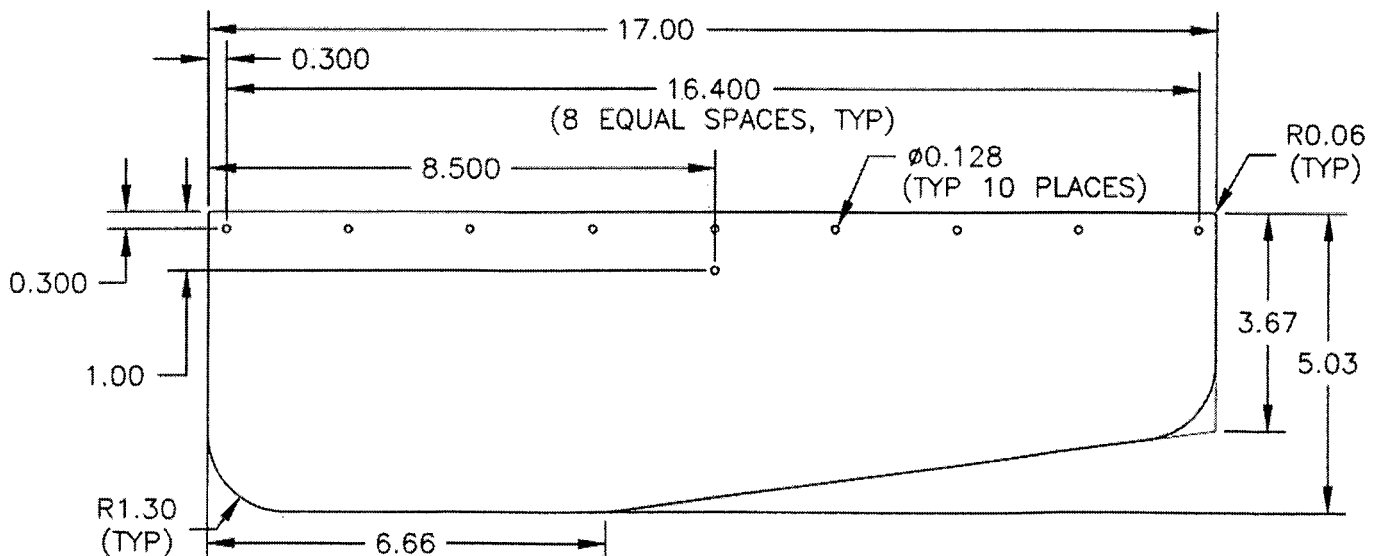
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12 *#*

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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